

Date: Monday, 4/23/2007 1:52:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 31994	
Estimate Number : 12722	
P.O. Number : <i>N/A</i>	Part Number : D353615
This Issue : 4/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30753	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/30/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 1.0340 sf(s)/Unit Total : 20.6808 sf(s)
 NEOPRENE SHEET 0.063
 Batch: *M103104*

JAW 07/05/03

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3536
 Dwg Rev: *A*
 Prog Rev: *A*

SAD 07/05/03

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/03

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SG 07.05.03

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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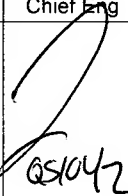

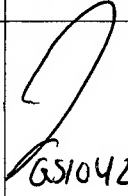

Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: *Fine skin*

7/5/4 5a 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/03	2.0	2 parts were Not in tolerance. Cut without a cover on the material	 GS1042	Scrap & destroy and <u>replace</u>	SAD 07/05/03	 070503	 GS1042	 070503

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 31994

Part Number: D353615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

2007/05/07

Job Completion



U 07-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31994
Description: Gasket		Part Number:	D3536-15
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.14	✓		M-T/Vern	
35.65	+/-0.030	35.64	✓		M-T/Vern	
33.65	+/-0.030	33.64	✓		M-T/Vern	
30.15	+/-0.030	30.15	✓		M-T/Vern	
24.90	+/-0.030	24.89	✓		M-T/Vern	
19.65	+/-0.030	19.64	✓		M-T-Vern	
14.40	+/-0.030	14.39	✓		M-T-Vern	
9.15	+/-0.030	9.14	✓		Vern	
5.65	+/-0.030	5.628	✓		Vern	
3.90	+/-0.030	3.89	✓		Vern	
8.00	+/-0.030	7.98	✓		Vern	
16.00	+/-0.030	16.02	✓		M-T/Vern	
24.00	+/-0.030	24.012	✓		M-T/Vern	
0.30	+/-0.030	0.312	✓		Vern	
0.30	+/-0.030	0.315	✓		Vern	
1.89	+/-0.030	1.910	✓		Vern	
Ø0.19	+0.005/-0.004	Ø0.197	✗		Vern	
Ø2	±0.030	Ø0.212 Ø0.199	✓		Vern	

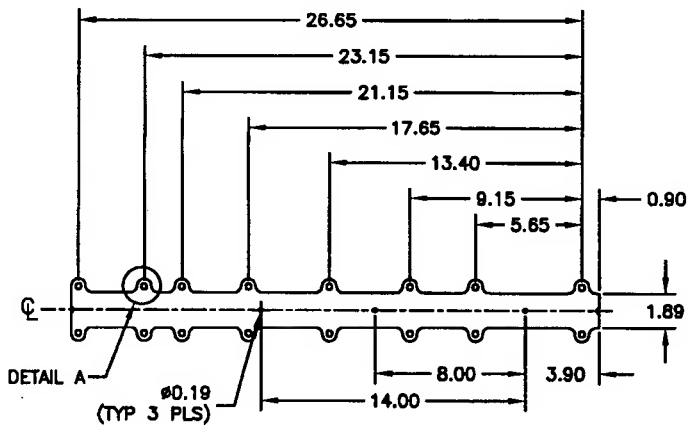
Measured by:	SAD	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	07/05/03	Date:	07.05.03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

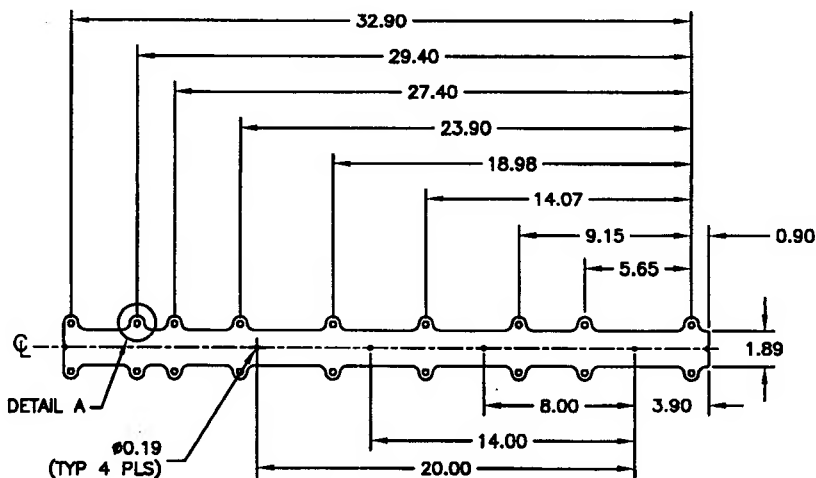
DART

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10

RELEASED
09.02.12



D3536-11 GASKET



D3536-13 GASKET

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WORK ORDER
NO. 31994

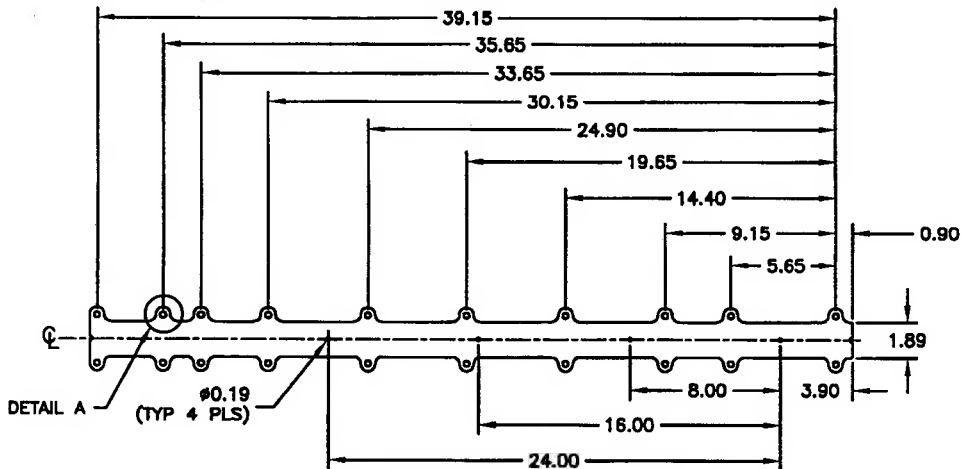
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

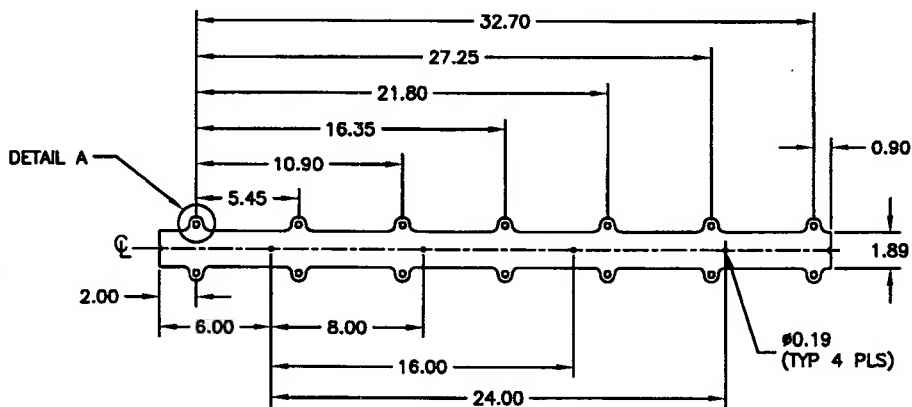
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

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D3536-15 GASKET



D3536-21 GASKET

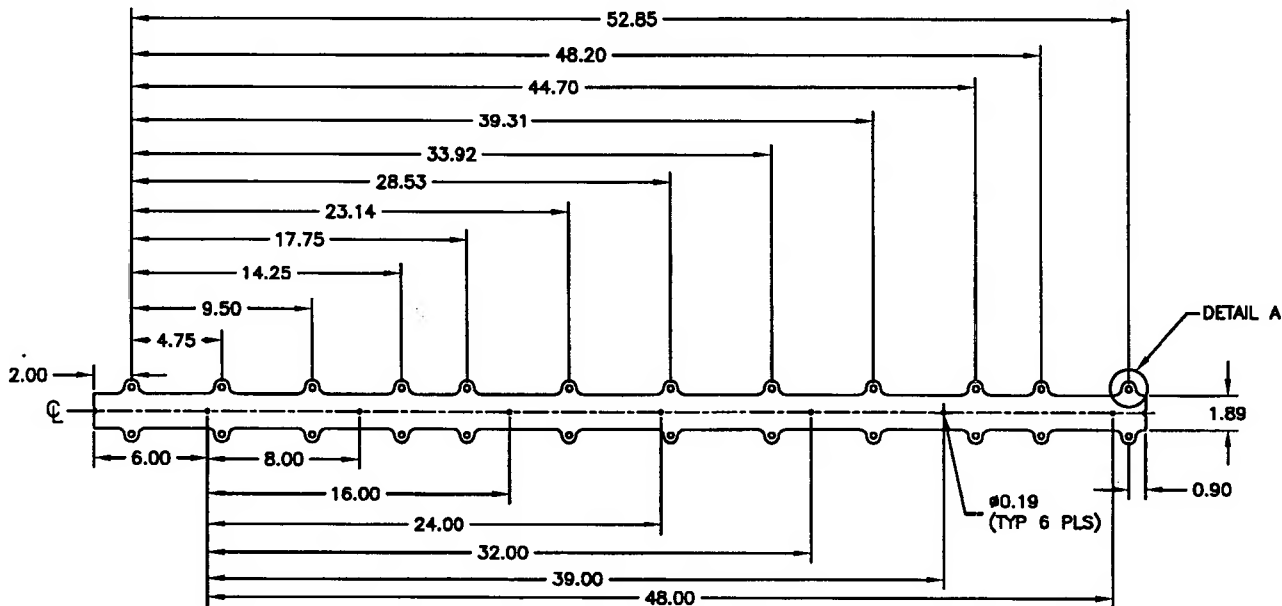
- NOTES
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT C
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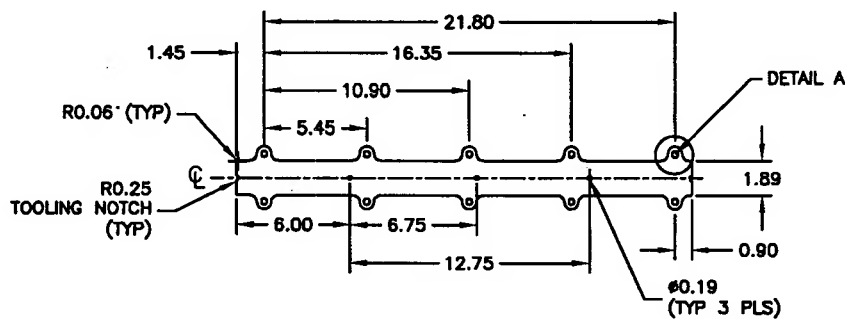
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 3 OF 6
		SCALE	1:10	

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D3536-23 GASKET



D3536-25 GASKET

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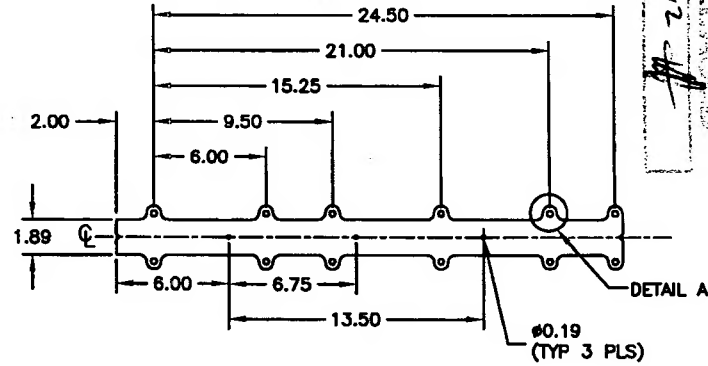
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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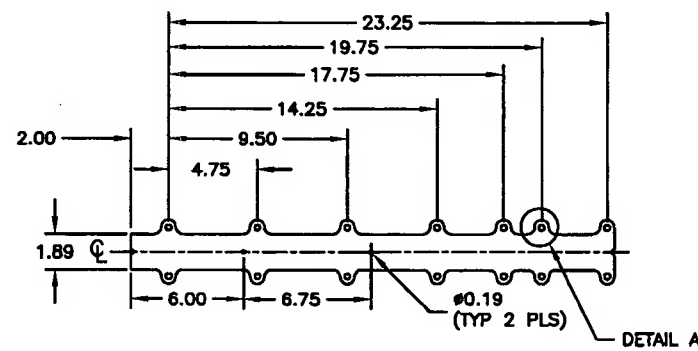
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	SHEET 4 OF 8
DATE	06.10.25	TITLE	GASKET	SCALE	1:10

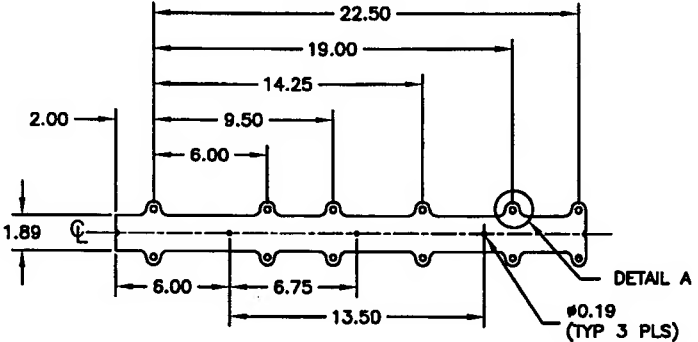
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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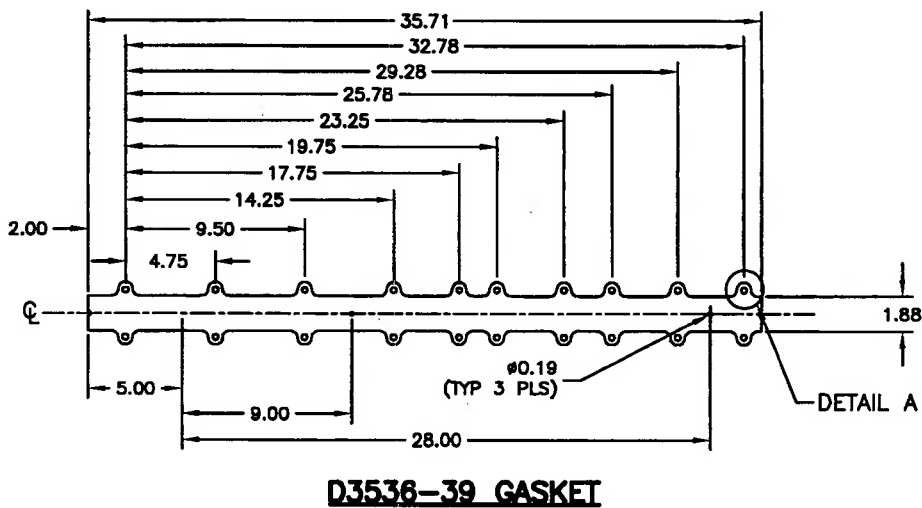
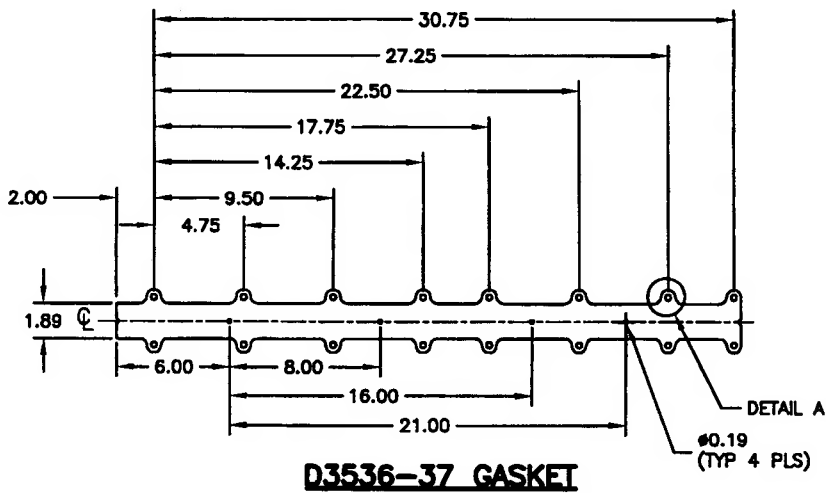
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CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6	
		SCALE 1:10	

07.02.12 *[Signature]*



NOTES

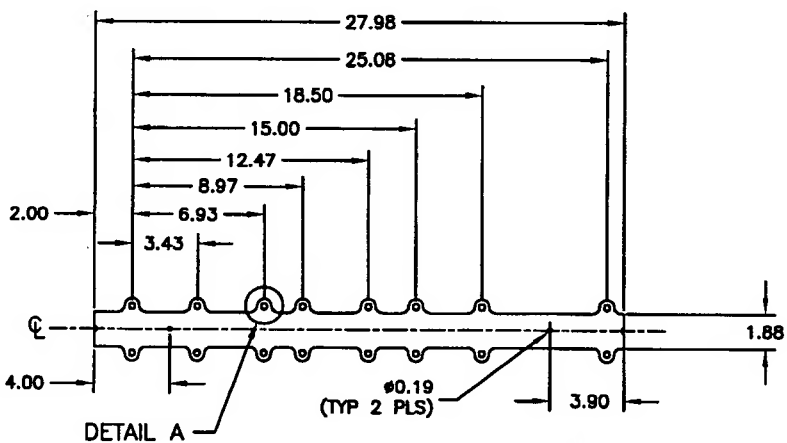
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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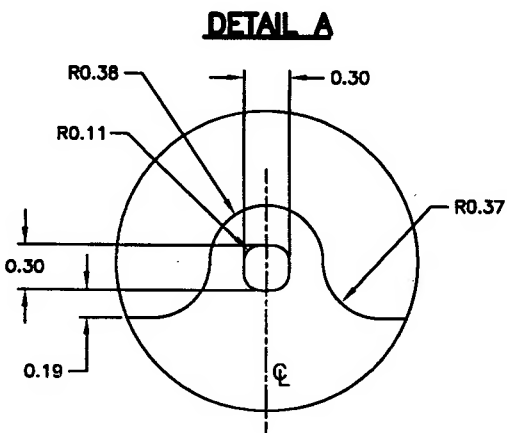
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. A
CHECKED PH	APPROVED PH	DRAWING NO. D3536	SHEET 6 OF 6
DATE 06.10.25	TITLE GASKET	SCALE 1:10	

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07.01.12 **CH**



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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